

AS/N

Date: Thursday, 11/29/2007 11:17:52 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	DOOR SLUG		
Job Number	36044		Part Number	D2587		
Estimate Number	10162		Drawing Number	D2587 REV A1		
P.O. Number	N/A		Project Number	N/A		
This Issue	11/29/2007	S.O. No.	N/A	Drawing Revision	A1	
Prsht Rev.	NC		Material	N/A		
First Issue	11/29/2007	Type	SMALL /MED FAB	Due Date	12/6/2007	Qty: 40 Um: Each
Previous Run	34307					
Written By						
Checked & Approved By						
Comment	Est D	04.05.31	Step 2 changed	KJ/JLM		
	Est E	06.07.31	Waterjet	EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S040	6061-T6 .040 Sheet 924
	Comment: Qty.: 0.0168 sf(s)/Unit Total : 0.6720 sf(s) 6061T6 alum. sheet 0.040" thick Batch: 102723 HB 07-12-4	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2587 Dwg Rev: A1 Prog Rev: A1	HB 07-12-4 SS
	2-Deburr if necessary	56
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE HB 07-12-4
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	03/12/05 (56) <i>coats</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	HB 07-12-06 (56)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR SLUG

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS 04/12/07

(X56)

Comment: INSPECT ALODINE

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST37

AS 04/12/07

(X56)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(56)

Comment: FINAL INSPECTION/W/O RELEASE

04/12/07

Job Completion



W 04/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36044
Description: Door Slug	Part Number:	D2587
Inspection Dwg: D2587 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

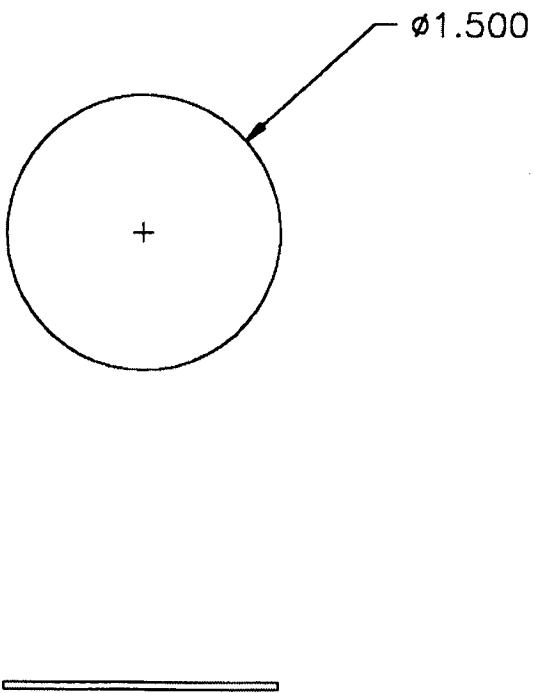
X First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>CD</u>	Prototype Approval:	N/A
Date:	07-12-4	Date:	07/12/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	SJL

DART

DESIGN MIKE M	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>M. M.</i>	APPROVED <i>M. M.</i>	DRAWING NO. D2587	REV. A SHEET 1 OF 1
DATE 96:07:11		TITLE DOOR SLUG	SCALE 1:1

RELEASED
9607/23 B&WA1 ~~Kyle~~ 03.09.16 ADD 6061-T6 OPTION

OR 6061-T6 (QQ-A-2008 OR QQ-A-225/8)
MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ECTCH, ALODINE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *36044*